



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D4776-3
Job Sheet 182375



Part No: D4776-3

Job Qty: 20 ea

Part Name: Skidtube Clevis



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/23/18

Job Tracking No:

Due Date: 9/7/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D SHEET 2 IPP REV A: NEW ISSUE JFS 13/03/07 VERIFY BY: JLM IPP REV:B 13.09.26 AS PER REV.B DD VERF:JLM IPP REV:C AS PER REV. PC1 JFS 13/11/07 VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	9/7/18	9/7/18	0.00	0.00	Start Up Machining-3		mmk 18/09/21
100	Bandsaw	20 pcs	9/7/18	9/7/18	0.00	0.36	Bandsaw1		"
110	CNC Vertical Machining	20 pcs	9/7/18	9/7/18	0.26	17.39	HAAS1-5		"
120	QC	20 pcs	9/7/18	9/7/18	0.00	0.00	QC2 Machining-3		"
130	QC	20 pcs	9/7/18	9/7/18	0.00	0.00	QC8 Machining-3		Kt 2018-09-28
140	HandFinish	20 pcs	9/7/18	9/7/18	0.00	0.53	HandFinish1		D.R. 18/10/18
150	QC	20 pcs	9/7/18	9/7/18	0.00	0.00	QC7-4		BK 18-10-2
160	Powdercoat	20 pcs	9/7/18	9/7/18	0.00	0.24	Powdercoat1		BK 18-10-2 DAS
170	QC	20 pcs	9/7/18	9/7/18	0.00	0.00	QC3		OCT 02 2018 68
180	Packaging	20 pcs	9/7/18	9/7/18	0.00	0.00	Packaging3-2	511.5	OCT 02 2018 9-89
190	QC21-SA	20 Ea	9/7/18	9/7/18	0.00	0.00	QC21		21 OCT 05 2018

Part Op 100 - Cut Blank at 4.400"
Descriptions: 110 - 1-Machine per folio FB168
160 - START TIME: 8:40 017300 FINISH: 9:10 MS3953.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.500X2.500	6061-T6 Bar 1.50 X 2.50	7.3400 ft (.367 ea)	90-Start up Operation	5108978

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.500X2.500	7	37	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Skidtube Clevis	4.250Inches ± 0.030	4.280 4.220	4.250	
2	Skidtube Clevis	2.250Inches ± 0.030	2.280 2.220	2.248	
3	Skidtube Clevis	1.688Inches ± 0.010	1.698 1.678	1.686	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : _____					

4	Skidtube Clevis	0.880Inches ± 0.030	0.910 0.850	.875
5	Skidtube Clevis	0.510Inches $+ 0.010$ $- 0.000$	0.520 0.510	.5125
6	Skidtube Clevis	1.063Inches ± 0.010	1.073 1.053	1.067
7	Skidtube Clevis	1.380Inches ± 0.030	1.410 1.350	1.380
8	Skidtube Clevis	0.190Inches ± 0.030	0.220 0.160	.190
9	Skidtube Clevis	1.000Inches ± 0.030	1.030 0.970	0.999
10	Skidtube Clevis	0.484Inches $+ 0.006$ $- 0.001$	0.490 0.483	.486 Diameter
11	Skidtube Clevis	0.500Inches ± 0.030	0.530 0.470	.498
12	Skidtube Clevis	0.550Inches ± 0.030	0.580 0.520	.550
13	Skidtube Clevis	3.150Inches ± 0.010	3.160 3.140	3.151
14	Skidtube Clevis	1.130Inches ± 0.030	1.160 1.100	1.125
15	Skidtube Clevis	0.688Inches ± 0.010	0.698 0.678	0.686
16	Skidtube Clevis	0.397Inches $+ 0.006$ $- 0.001$	0.403 0.396	.400 Diameter
17	Skidtube Clevis	1.813Inches ± 0.010	1.823 1.803	1.815
18	Skidtube Clevis	0.190Inches ± 0.030	0.220 0.160	.190 Radius
19	Skidtube Clevis	0.130Inches ± 0.030	0.160 0.100	.130 Radius
20	Skidtube Clevis	0.440Inches ± 0.030	0.470 0.410	.440 Radius
21	Skidtube Clevis	0.125Inches ± 0.010	0.135 0.115	.122
22	Skidtube Clevis	0.380Inches ± 0.030	0.410 0.350	.380
23	Skidtube Clevis	0.750Inches ± 0.030	0.780 0.720	.750
24	Skidtube Clevis	0.250Inches ± 0.030	0.280 0.220	.250 Radius

Plex 8/23/18 10:15 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date : _____	Step #: _____			MRB (QSI042) Approval																	
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 932-5200 Email: sales@dartaero.com www.dartaero.com Container No: S112286 Part: D4776-3 Job No: 182375 Serial No/Batch: S112286 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 09/21/18				Disposition Completed By Lead hand / Supervisor Approval QC / QA Coordinator Approval																	
ATEGORY																					
Envir Equip/ Handli Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified	Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Cripp/kink/kipple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
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